

Work Order ID 133905

133905

Page 1

Tuesday, June 23, 2015 3:14:25 PM

Item ID: D2594-3 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: O-Ring Stop *NS2*

Start Date: 6/23/15 Start Qty: ²⁰⁰150.00 *150* JUN 24 2015 Cust Item ID:

Required Date: 6/23/15 Req'd Qty: ²⁰⁰150.00 *150* Customer:

Reference:

Approvals: Process Plan: WLS Date: JUN 24 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2594	Rev C

100 PURCHASING 0.00

100

Purchasing Memo 0.00

Purchasing Issue P/O: 28928 Purchase as per Dwg D2594 Possible P/N: Parker 2-011 Material release note is required

CX JUN 24 2015 200

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging Memo 0.00

Packaging Ensure Material Release Note is attached

200X SP15-06-25

120 QC6- Inspect dimensions to drawing 0.00

120

QC Memo 0.00

Quality Control

200 JUN 26 2015

DAS
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 133905

133905

Page 2

Tuesday, June 23, 2015 3:14:25 PM

Item ID: D2594-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: O-Ring
 Start Date: 6/23/15 Start Qty: 150.00 *150* Cust Item ID:
 Required Date: 6/23/15 Req'd Qty: 150.00 *150* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP001</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

CL 15/06/26 200
ML5 JUN 29 2015
ML5 JUN 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

Tuesday, June 23, 2015 3:14:25 PM

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133905

D2594-3

Required Date: 6/23/15

Required Qty: 150.00

Comments: IPP B04.06.08Reformat; Added Powder CoatKJ/JLM
IPP C 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS28775-011

Purchased

No

100

Each

0.0000

1

150

MS28775-011

O-Ring

200 x 80 15-06-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

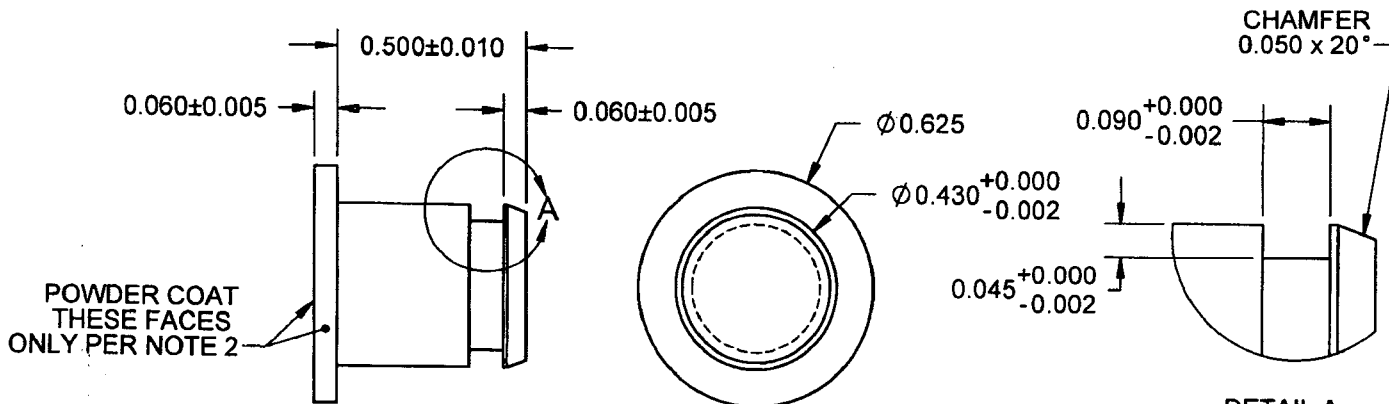
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

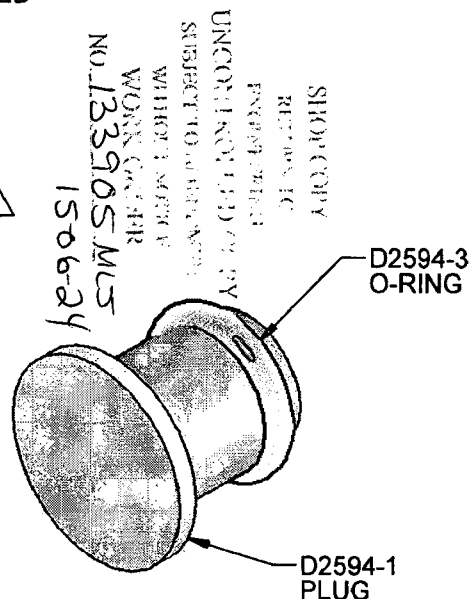
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28928**

Purchase Order Date 6/24/2015

PO Print Date 6/24/2015

Page Number 2 of 2

Order From : VU-EC001

EAST COAST AVIATION SUPPLIES, INC.
399 EAST DRIVE
MELBOURNE, FLORIDA 32904
USA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 1-321-727-0047

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB FCA - (Free Carrier)

Line Total: \$61.50

5	MS28775-011	O-Ring	6/25/2015	200.00	\$0.14	\$28.00
			Yes	Each		
			6/25/2015			

AS PER DWG D2594 REV. C
B133905

Line Total: \$28.00

6	71401-45	procurement quality clauses	6/25/2015	1.00	\$0.00	\$0.00
			No			
			6/25/2015			

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 PUBLIC LAW 101-592 FASTENER QUALITY ACT
A033 STATEMENT OF CONFORMITY/TEST RECORDS
FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A043 RETENTION OF QUALITY DOCUMENT

Line Total: \$0.00

PO Total: \$126.70

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 6/24/2015



ECAS, LLC.
Your World-Class Aerospace & Defense Supplier

Packing Slip

Original

Invoice #: 528600
Date Printed: 6/24/2015
Time: 5:06:47 PM
of Items: 4
Page: 1

To:

DART AEROSPACE LTD.
ACCTS. PAYABLE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
CANADA

ATTN: MICHAEL
Ph: 613.632.9577 Fax: 613.632.1053

Ship To:

DART AEROSPACE LTD.
ATTN: RECEIVING
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
CANADA

Invoice Date: 6/24/2015

Terms: NET 30

Weight: 8

Ship Via: FEDEX INT'L COLL

Order Date: 6/24/2015

Cust. PO#: PO28928

of Boxes: 1

Ship Date: 6/24/2015

FOB: MELBOURNE, FL

Shipment #:

Sales Order: 474216

Customer #: 16754

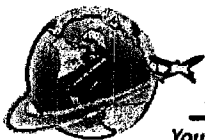
AWB: 6244 7807 1910

ECAS Contact: LUIS

Item	Part Number/Description	Shipped	BackOrd	CD	Unit Price	UoM	Total Amt
✓ 1	MS29512-06 O'RING	✓ 20.00	0.00	NE			
✓ 2	AN4-20A BOLT UNDRILLED	✓ 100.00	0.00	NE			
✓ 3	AN3C21A BOLT UNDRILLED S/S	✓ 30.00	0.00	NE			
✓ 4	MS28775-011 O'RING	✓ 200.00	0.00	NE			

Gas 06-25

Authorized Signature:



ECAS, LLC.
Your World-Class Aerospace & Defense Supplier

Invoice

Original

Invoice #: 528600
Date Printed: 6/24/2015
Time: 5:06:36 PM
of Items: 4
Page: 1

To:

DART AEROSPACE LTD.
ACCTS. PAYABLE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
CANADA
ATTN: MICHAEL

Ship To:

DART AEROSPACE LTD.
ATTN: RECEIVING
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
CANADA

Invoice Date: 6/24/2015 Terms: NET 30 Weight: 8 Ship Via: FEDEX INT'L COLL
Order Date: 6/24/2015 Cust. PO#: PO28928 # of Boxes: 1
Ship Date: 6/24/2015 FOB: MELBOURNE, FL Shipment #: 1
Sales Order: 474216
Customer #: 16754 AWB: 6244 7807 1910 ECAS Contact: LUIS

Item	Part Number/Description	Shipped	BackOrd	CD	Unit Price	UoM	Total Amt
✓ 1	MS29512-06 O'RING	✓ 20.00	0.00	NE	0.3600	EA	\$7.20
✓ 2	AN4-20A BOLT UNDRILLED	✓ 100.00	0.00	NE	0.3000	EA	\$30.00
✓ 3	AN3C21A BOLT UNDRILLED S/S	✓ 30.00	0.00	NE	2.0500	EA	\$61.50
✓ 4	MS28775-011 O'RING	✓ 200.00	0.00	NE	0.1400	EA	\$28.00
*** Order Complete ***							

6/25-05-25

Authorized Signature:	SubTotal:	\$126.70
	Tax Total:	\$0.00
	Misc Charge:	\$0.00
	Freight:	\$0.00
	Total:	\$126.70
		USD

East Coast Aviation Supplies, Inc.
CERTIFICATE OF CONFORMITY

Original

No: 528600

Bill To:

Ship To:

ORIGINAL

DART AEROSPACE LTD.
ACCTS. PAYABLE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7

DART AEROSPACE LTD.
ATTN: RECEIVING
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7

Customer PO	Ship Date	Airway Bill Number
PO28928	6/24/2015	6244 7807 1910

Part No.	Description	Cond	Qty	S/L
MS29512-06 MFR: PARKER LOT: 0080221310	O'RING ECCN#: EAR99 SCHB#: 4016.93.1010	NE	20	37
AN4-20A MFR: AFC LOT: 23012	BOLT UNDRILLED ECCN#: 9A991 SCHB#: 7318.15.2000	NE	100	29
AN3C21A MFR: AFC LOT: 13423	BOLT UNDRILLED S/S ECCN#: 9A991 SCHB#: 7318.15.2091	NE	30	8
MS28775-011 MFR: PRECIX LOT: 13269003	O'RING ECCN#: EAR99 SCHB#: 4016.93.1010	NE	200	36

SP 15-06-25

CONDITIONS: NE - New NS - New Surplus OH-Overhauled RP-Repaired SV-Serviceable

We hereby certify that the items that are a part of this Purchase Order have been visually & dimensionally found to conform to all applicable standards, drawings & specifications. The liability of ECAS is limited to replacement of any item which is rejected because of a defect in material or workmanship if notified within 30 days & liability shall not exceed the invoice value. Such replacement shall constitute satisfaction of all liability.

Signed:

For and on behalf of EAST COAST AVIATION SUPPLIES, INC.

Insp.
#2

Inspectors Stamp